

Work Order ID 80772

Tuesday, February 28, 2012 3:05:32 PM

80772

March 8

Page 1

Item ID: D350-607-541

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Utility-Basket

Start Date: 2/28/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/6/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *mf*Date: *12-02-28*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-607-3	A								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPPD350-607-541 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging	****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label****								
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

*S 12/03/08**1003 per ESN 12535
(D3912-041 ss plunger
D3801-1)**SD 12-03-07**S 12/03/08**(40)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 3/6/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

Pick Kit

0.00

130

Packaging

Memo

0.00

Packaging

Package as per PPPD350-607-541

1x Sp 12-3-07

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 12/03/08

MLJ
12/03/08
①

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Picklist Print

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Work Order ID: 80772
Parent Item: D350-607-541
Parent Item Name: Heli-Utility-Basket

Start Date: 2/28/2012

Required Date: 3/6/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10-08-19 AS PER REV.A DD VERF BY:EC IPP Rev:B 11.02.09 add to install label DD verf by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-607-511 Quick Release Basket Mounting Installation	417602	Manufactured	No			110	Each	0.0000					
D2690-6 Lanyard Assembly		Manufactured	No			110	Each	30.0000					

Location	Loc Qty	Loc Code
ST016	30	
79515	30	

D3912-041 Eyebolt Receiver Assembly	w/SS plunger	Manufactured	No			110	Each	1.0000					
--	--------------	--------------	----	--	--	-----	------	--------	--	--	--	--	--

Location	Loc Qty	Loc Code
st507	1	
77576	1	

D4030-041 Long Basket Assembly (350)		Manufactured	No			110	Each	0.0000					
---	--	--------------	----	--	--	-----	------	--------	--	--	--	--	--

D4085-3 Placard, Instructions		Manufactured	No			110	Each	7.0000					
----------------------------------	--	--------------	----	--	--	-----	------	--------	--	--	--	--	--

Location	Loc Qty	Loc Code
ST122	7	
78972	7	

D4151-041 Basket Fwd Hardpoint Assembly, Lower		Manufactured	No			110	Each	5.0000					
---	--	--------------	----	--	--	-----	------	--------	--	--	--	--	--

Location	Loc Qty	Loc Code
ST131	2	
78970	2	
ST134	3	
77604	3	

SP B80777 SP

IX B80995 SP
12-03-8.
80773 2/23/12 SP

IX SP 12-3-07 SP

IX

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Parent Item: D350-607-541

Parent Item Name: Heli-Utility-Basket

Start Date: 2/28/2012

Required Date: 3/6/2012

Start Qty: 1.00

Required Qty: 1.00

D4151-043
Basket Fwd Hardpoint Assembly, Upper

Manufactured No

110 Each 2.0000

Location

Loc Qty

Loc Code

ST134

2

79345

2

D4150-041
Attachment Arm Assembly

Manufactured No

110 Each 2.0000

Location

Loc Qty

Loc Code

ST134

2

79355

2

AN4-13A
Bolt

Purchased No

110 Each 1,633.0000

Location

Loc Qty

Loc Code

ST357

1633

119449

59

120187

674

120422

500

120770

400

AN4C15
BOLT

Purchased No

110 Each 38.0000

Location

Loc Qty

Loc Code

ST358

38

120124

38

AN310C4
Nut

Purchased No

110 Each 55.0000

Location

Loc Qty

Loc Code

ST344

55

119324

25

120360

30

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Shop Packet Print

Page 2

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Work Order ID: 80772

Parent Item: D350-607-541

Parent Item Name: Heli-Utility-Basket

Start Date: 2/28/2012

Required Date: 3/6/2012

Start Qty: 1.00

Required Qty: 1.00

MS17984-C413
PIN; QUICK RELEASE

Purchased No

110 Each 11.0000 1

Location	Loc Qty	Loc Code
ST315	11	
114340	1	
118612	2	
120123	2	
120360	5	
120521	1	

MS21042L4
Nut

Purchased No

110 Each 4.638.0000 6 6

Location	Loc Qty	Loc Code
ST300	4638	
117441	59	
117601	157	
118451	133	
119017	200	
119075	4089	

MS24665-151
Cotter Pin

Purchased No

110 Each 323.0000 1

Location	Loc Qty	Loc Code
ST309	323	
17566	323	

NAS1515H4L
WASHER

Purchased No

110 Each 656.0000 2

Location	Loc Qty	Loc Code
FG	8	
103691	8	
ST277	648	
118709	148	
120390	500	

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Parent Item Name: Heli-Utility-Basket

Start Date: 2/28/2012

Required Date: 3/6/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P

Washer

Purchased

No

110

Each

270.0000

12

12

Location

Loc Qty

Loc Code

ST275

270

120142

70

120360

200

NAS1149C0463R

Washer

Purchased

No

110

Each

1.178.0000

3

3

Location

Loc Qty

Loc Code

FP001

1

115358

1

ST297

1177

117735

177

119097

1000

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4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-607-541 (Standard Basket)	80.7 lb 36.6 kg	± 49.1 in ± 1.25 m	± 3962 in-lb ± 45.8 m-kG	135 in 3.43 m	10895 in-lb 125.5 m-kG
D350-607-543 (Lightweight Basket)	65.7 lb 29.8 kg	± 49.1 in ± 1.25 m	± 3226 in-lb ± 37.3 m-kG	135 in 3.43 m	8870 in-lb 102.2 m-kG
D350-607-545 (Standard Basket)	58.7 lb 26.2 kg	± 49.1 in ± 1.25m	± 2882 in-lb ± 32.8 m-kG	135 in 3.43 m	7925 in-lb 89.9 m-kG
D350-607-547 (Lightweight Basket)	47.7 lb 21.6 kg	± 49.1 in ± 1.25 m	± 2342 in-lb ± 27.0 m-kG	135 in 3.43 m	6440 in-lb 74.1 m-kG
D350-607-511 (Quick Release Basket Mounting Kit)	7.2 lb 3.3 kg	± 36.9 in ± 0.94 m	± 266 in-lb ± 3.1 m-kG	135 in 3.43 m	972 in-lb 11.3 m-kG

5.0 PARTS LIST

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET
	X					D350-607-543	HELI-UTILITY-BASKET
		X				D350-607-545	HELI-UTILITY-BASKET
			X			D350-607-547	HELI-UTILITY-BASKET
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT
					X	D350-607-501	CONVERSION KIT
1	1	1	1		1	D2690-6	LANYARD
				4	4	D3910-3	X-TUBE LUG
1	1	1	1		1	D3912-041	EYEBOLT RECEIVER ASSY
				8	8	D3984-030	RUBBER EXTRUSION, X-TUBE
1						D4030-041	LONG BASKET ASSY
	1					D4030-043	LONG BASKET ASSY, LIGHTWEIGHT
		1				D4032-041	SHORT BASKET ASSY
			1			D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
1	1	1	1		1	D4085-3	PLACARD-INSTRUCTIONS
1					1	D4086-200	PLACARD, MAX LOAD
	1				1	D4086-215	PLACARD, MAX LOAD
		1			1	D4086-220	PLACARD, MAX LOAD
			1		1	D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
1	1	1	1		1	D4150-041	ATTACHMENT ARM ASSY
1	1	1	1		1	D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
1	1	1	1		1	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
6	6	6	6		6	AN4-13A	BOLT
				16	16	AN4-14A	BOLT
1	1	1	1		1	AN4C15	BOLT
1	1	1	1		1	AN310C4	CASTELLATED NUT
1	1	1	1		1	MS17984-C413	QUICK RELEASE PIN
6	6	6	6	16	22	MS21042L4	NUT (OR MS21042-4)
1	1	1	1		1	MS24665-151	COTTER PIN
2	2	2	2		2	NAS1515H4L	WASHER
12	12	12	12	32	44	NAS1149F0432P	WASHER
3	3	3	3		3	NAS1149C0463R	WASHER

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Revision: A

Date: 10.06.28

Work Order ID 80772

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March 2012

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Approvals: Process Plan: *MF*

Date: *12-02-28*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D350-607-3

A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-541 CHG002

MLJ 12/03/08
(1)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

Mask label plate to size of D4086 label. use scotchbrite red pad to lightly sand area for label. apply label

120

QC4-100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control